

Date: Thursday, 3/16/2006 10:37:42 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: BLOWER MOTOR SUPPORT
<b>Job Number</b>	: 26269		
<b>Estimate Number</b>	: 12308		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D34711
<b>This Issue</b>	: 3/16/2006	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D3471 REV.A
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 26125	<b>Drawing Revision</b>	: A
	<b>Type</b> : SMALL /MED FAB	<b>Material</b>	:
<b>Written By</b>	: _____	<b>Due Date</b>	: 3/31/2006
<b>Checked &amp; Approved By</b>	: _____	<b>Qty:</b>	1 Um: Each
<b>Comment</b>	: est rev A 06.03.02 New issue EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	OUTSIDE SERVICE	OUTSIDE SERVICES
-----	-----------------	------------------



**Comment:** Sub-Contracting OUTSIDE SERVICES  
 Issue P/O: \_\_\_\_\_  
 Email or Ship DXF file to vendor  
 Cut per Dwg D3471 flat pattern D3471-1F  
 possible supplier: GFI  
 Material release note required

2.0	D34711F	BASE FLAT PATTERN
-----	---------	-------------------



**Comment:** Qty.: 1.0000 sf(s)/Unit Total: 1.0000 sf(s)  
 SUPPORT FLAT PATTERN

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1  
 Receive & Inspect For Transit Damage  
 Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



**Comment:** DIMENSIONAL CHECK  
 Ensure Material certification comply to Dwg D3471

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



**Comment:** SMALL & MEDIUM FAB RESOURCE 1  
 1-Deburr  
 2-Bend as per dwg D3471

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Date:** Thursday, 3/16/2006 10:37:42 AM  
**Usef:** Kim Johnston

## Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services

**Drawing Name:** BLOWER MOTOR SUPPORT

**Job Number:** 26269

**Part Number:** D34711

Job Number:



**Seq. #:**

**Machine Or Operation:**

**Description :**

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



**Comment:** HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

QC5

INSPECT WORK TO CURRENT STEP



**Comment:** INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0

DC

DOCUMENT CONTROL



**Comment:** DOCUMENT CONTROL

Inspection Level 21

Job Completion



**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

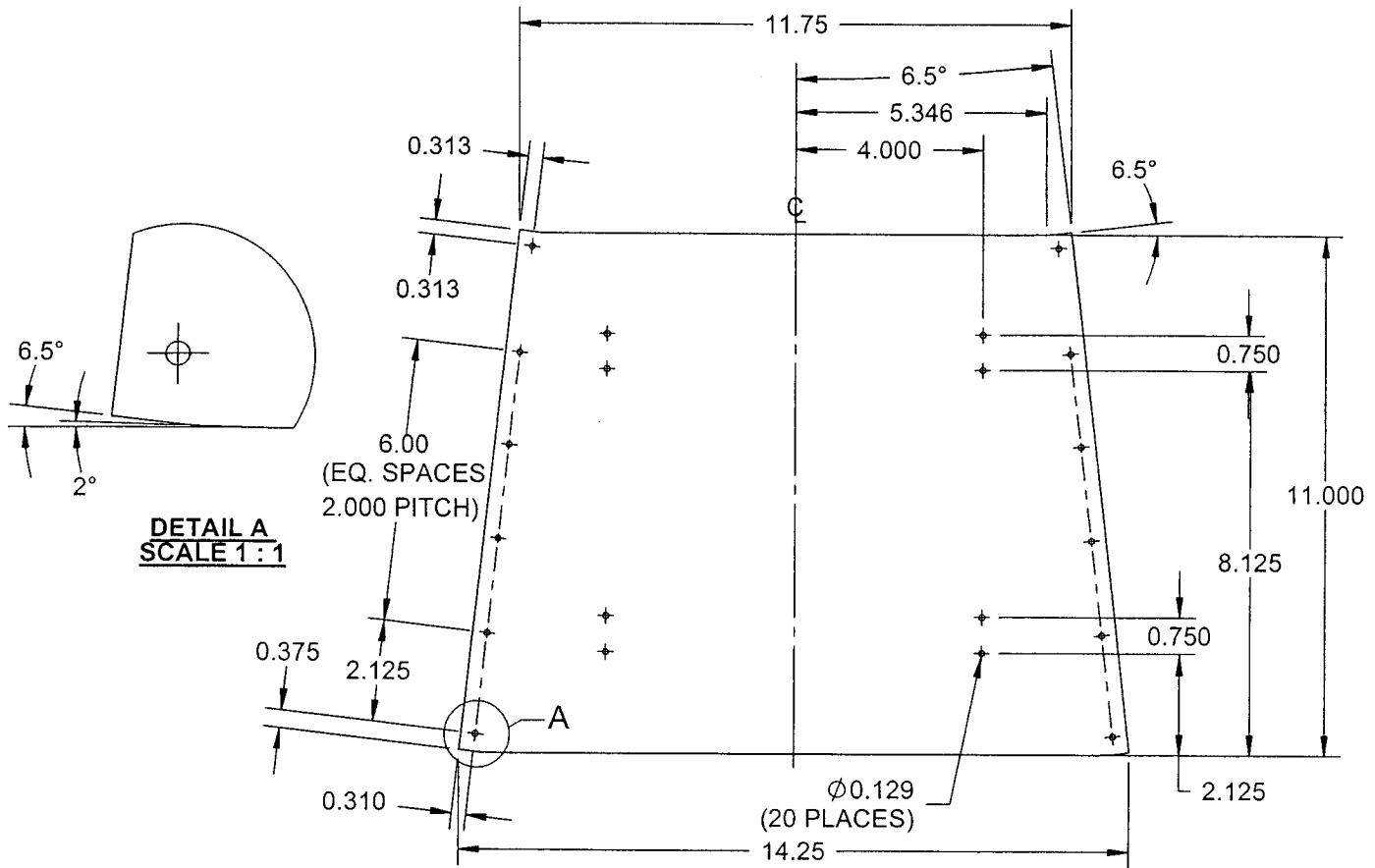
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

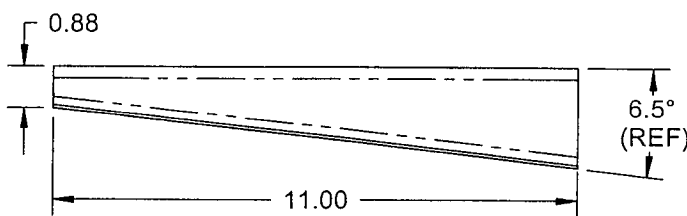
**NOTE:** Date & initial all entries

PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3471	REV. A SHEET 3 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:4



**D3471-1F BASE FLAT PATTERN**



**D3471-1 BASE BENDING DETAIL**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.040" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRICAL ABOUT CENTER LINE
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **26266**

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.